

Work Order ID 77050

77050

Page 1

November-25-11 8:30:51 AM

Item ID: D3041-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clamp

Start Date: 25/11/2011 Start Qty: 24.00

24

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: ML5Date: 11/11/25 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 Extrusion: 1.250" Long

cut @ meter

CL 11/11/28

110 French

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio FA153

DWG REV: _____

FOLIO REV: _____

issue P10 to meter P10:15552
 machine as per dwg D3041-REV.C.

CL 11/11/28 24

120 red

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

red + inspect for transit damage.
 attached C of C to WIO:

11/12/16 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3041-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 25/11/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

160

Powdercoat

Powder Coating

Memo

0.00

Mask inside of 0.8120" diameter hole

START TIME: 10:50

OVEN TEMPERATURE: 320

FINISH TIME: 11:20

24xØ m-11/12/14

170	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

170

QC

Quality Control

Memo

0.00

24xØ 11/12/14
counted

180	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

180

Small Fab

Small Fab

Memo

0.00

1- Press D2611 bearing into lug as per Dwg D304

2- Stake bearing into place as per Dwg D3041

EP 11/12/20 (24)

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 Required Date: 09/12/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>cut</i> (24)			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: 462 Memo	0.00 0.00							<i>11/12/22</i> 24
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>11/12/22</i> MF <i>11-12-22</i>

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November-25-11 8:30:54 AM

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D3041-1

Required Date: 09/12/2011

Required Qty: 24.00

Comments: IPP RevA: as per revC1 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2611		Manufactured	No			100	Each	30.0000	1	24			
D2611									**				
Bearing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST018				30					
				68916				30					
D2423		Manufactured	No			180	f	447.8800	0.0833	2.104421			
D2423									**				
Lug Extrusion													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT006				447.88					
				43722				161.5					
				45800				1					
				68331				285.38					

D 3041-1 P.

* 24

Puffe (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

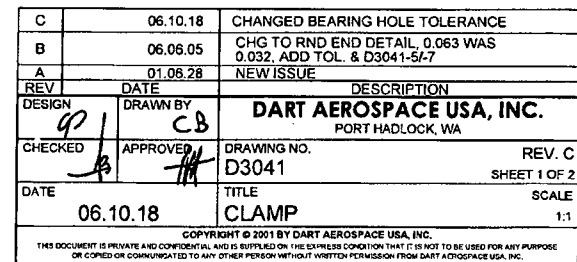
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NO. 77050 4. C. J.
1111125



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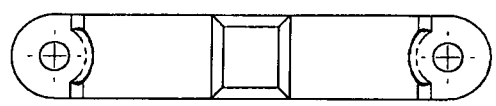
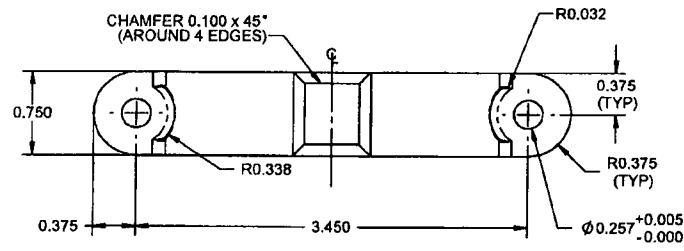
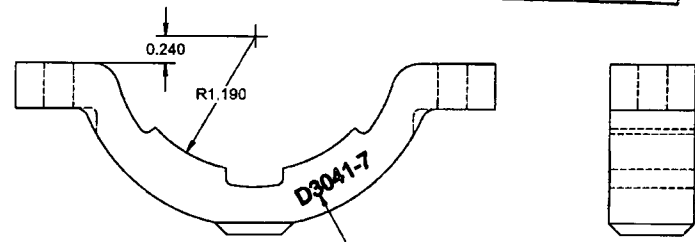
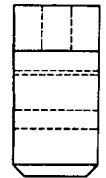
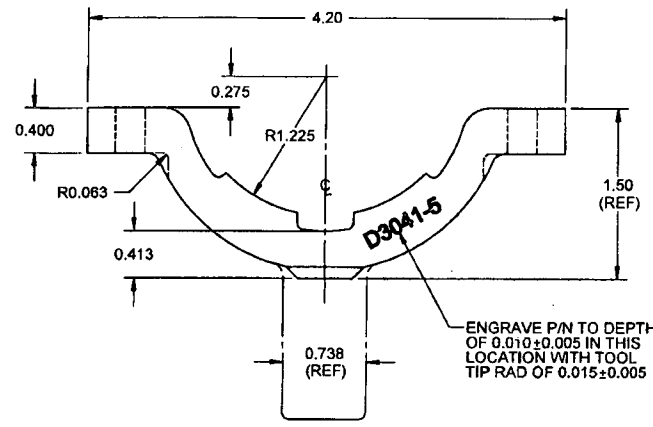
NOTE: Date & initial all entries

77050

DEO ATTACHE

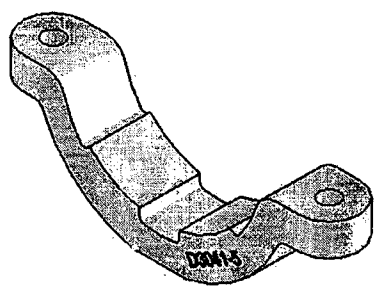
RELEASED

06.11.17



D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
 - 6) PART IS SYMMETRIC ABOUT C

DESIGN 97	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP	SCALE 1:1	
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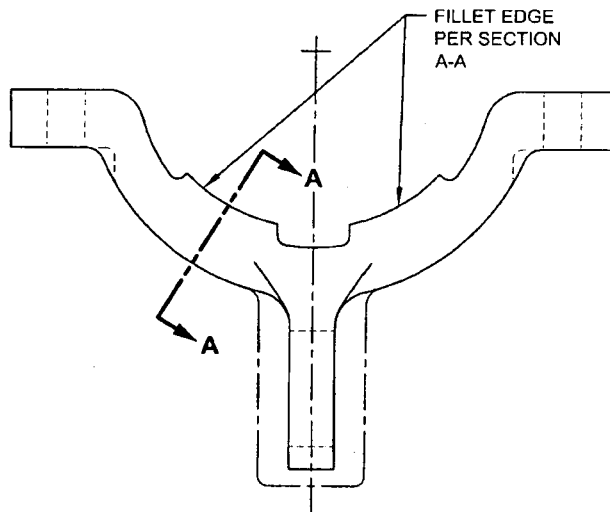
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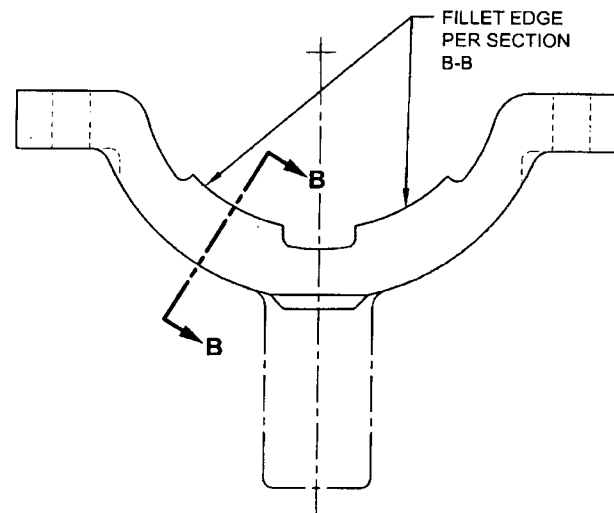
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED	DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13	DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



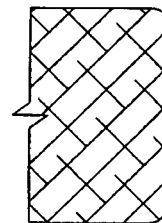
D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15552

Purchase Order Date 11/28/11

PO Print Date 11/28/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

RECEIVED
\$

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3041-1P	Clamp	12/09/11 Yes	24.00 Each	Dart Truck	\$42.0000	\$1,008.00
Special Inst:			AS PER DWG D3041 REV. C B77050				
2	D3041-3P	CLAMP	12/09/11 Yes	24.00 Each	Dart Truck	\$42.0000	\$1,008.00
Special Inst:			AS PER DWG D3041 REV. C B76997				

PO Total:

\$2,016.00

Change Nbr:

2

Change Date: 11/28/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18301
Date: Dec 06, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Chantal Lavoie 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 15552	Sold By: Dewar, Eric
Shipped By: our truck	Ship Date: Dec 06, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3041-1 Clamp as per Dwg D3041 REV.C B77050	Each	24	24	
D3041-3 Clamp as per DWG D3041 REV.C B76997 Materials supplied by Dart	Each	24	24	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by _____

Thank you for your order!



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
24	D3041-1P	Clamp <i>Suzlog</i>	PO15552
24	D3041-3	Clamp	PO15552

MATERIAL: supplied by DART D3041 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, December 6 2011